

**Work Order ID 79410**

Wednesday, January 25, 2012 3:06:21 PM

**\*79410\***

Page 1

Feb 3<sup>rd</sup>

Item ID: D206-642-612

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Float Skidtube RH

Start Date: 1/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: REWORK

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
PN	D206-642-612	CHG	CHG003
DESC	Float Skidtube RH	STC	SH98-4
LOT	B36958	STC	SA00475SE
MODEL	Bell 206A/B	STC	
US PATENT # 5,735,484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

Approvals: Process Plan: *mf*Date: *12-01-25* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D206-642	0

150

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK D206-642-612 B 36958

CHG003

REMOVE CAP AND WASH LPS3 OUT OF TUBE PER ECN 09-616

*12 01 30 (1)*  
*for MLS 12-1-31*

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*12-01-31*

170

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

RE-ASSEMBLE D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 *119508*Sikaflex expire date: *12/08**At 12 - 1 - 31***B79410 D206-642-612**

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Wednesday, January 25, 2012 3:06:21 PM

Item ID: D206-642-612

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Float Skidtube RH

Start Date: 1/25/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									
190	Pick Kit	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging	REMOVE D3672-5 X 16 AND REPLACE WITH D3672-7 X 16 PER DSI 9467 (ECN 09-616)								
200	QC4- 100% Inspect kits for completeness	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

12-01-31 (1)

12/1/11

40

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Item ID: D206-642-612

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Float Skidtube RH

Stop **\*NS2\***

Start Date: 1/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER AND NEW CHANGE NUMBER

ADD NEW PAPERWORK

CHG004

SP 12-02-01

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

M.C.S 12/02/01

ME 12-02-01

# Picklist Print

Wednesday, January 25, 2012 3:06:21 PM

Page 1

Work Order ID: 79410

Parent Item: D206-642-612

Parent Item Name: Float Skidtube RH

Start Date: 1/25/2012

Required Date: 1/31/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.27 Revised pick list KJ/EC  
 IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM  
 IPP Rev:D 07-12-05 ECN 1080p Rev:L DD verified by:ec  
 IPP Rev:E 09-01-06 update part list DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3672-5 Phenolic Washer		Manufactured	No				Each	1,864.0000		-16			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST060	1864	
35521	1075	
44679	220	
50354	569	

D3672-7 Phenolic Washer		Manufactured	No				Each	1,068.0000					
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST060	1068	
73488	68	
76279	1000	

*SP*

16

12/21/11

*SP*

16

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

#### GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: NONE
7. WEIGHT: 20.8 LBS
8. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
9. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
10. ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
11. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291
13. WELDING: PER DART QSI 004
14. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

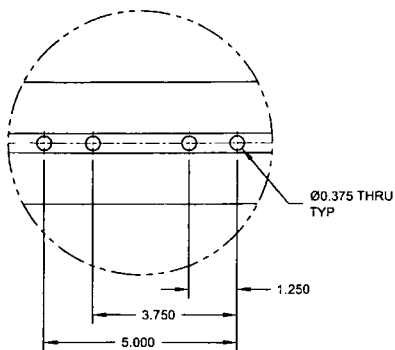
G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

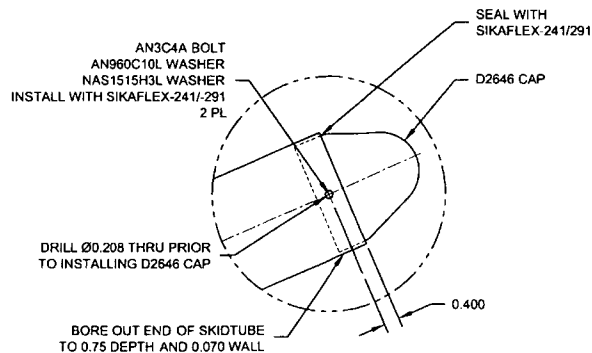
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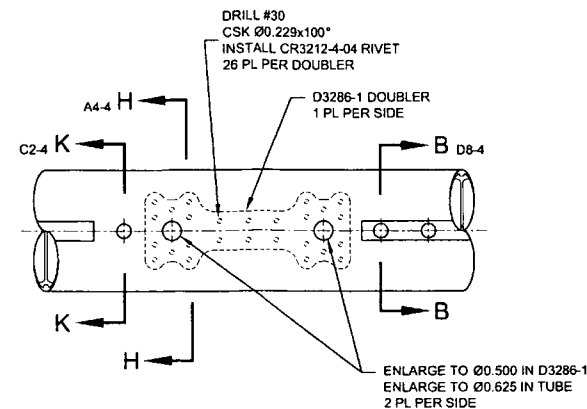




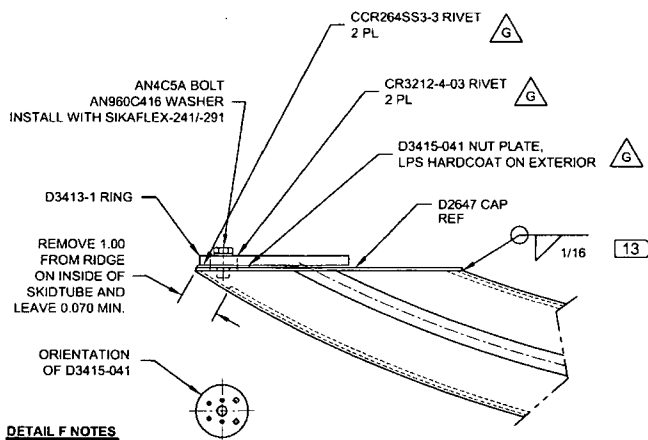
**DETAIL A: DRILL DETAIL** D6-2, D4-2  
SADDLE HOLES, SCALE 5X



**DETAIL E** B3-2  
SCALE 5X



**DETAIL G** B5-2  
SCALE 5X



**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

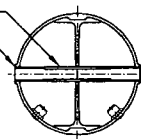
**DETAIL F: END FINISHING DETAIL** B7-2  
SCALE 5X

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09/06/17

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MFG. APPR.		D3288	SHEET 3 OF 4
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D2649 SPACER

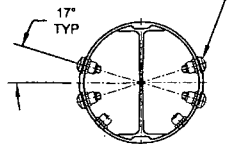
13



AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR Ø0.375 SADDLE HOLES ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE TO Ø0.313x0.75 DEEP

B7-2, B5-2, D1-3  
**SECTION B-B**  
FOR Ø0.375 SADDLE HOLES ONLY  
8 PL, SCALE 5X

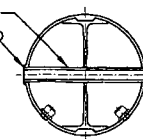
AFTER FINISH, INSTALL D3683-1 INSERT AND PLUG INSERTS USING MS27039C1-05 SCREWS AND AN960C10L WASHERS 12 PL



11  
**SECTION J-J**  
SCALE 5X D5-2, B6-2

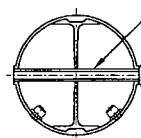
D2649 SPACER

13



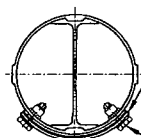
AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THIS HOLE ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH

B5-2  
**SECTION K-K**  
1 PL, SCALE 5X



D3275-1 SPACER  
CHAMFER 0.030x45° TYP

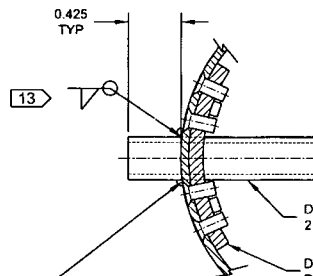
**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
6 PL, SCALE 5X



GASKET WEARSHOE WEARPAD REF

ALS7-1032-130 INSERT  
AN3C4A BOLT  
AN960C10L WASHER  
64 PL

12  
**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
32 PL, SCALE 5X



TO INSTALL D3286-1/3:  
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE  
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1  
3. ENLARGE HOLES IN D3286-1 TO Ø0.500  
4. ENLARGE HOLES IN TUBE TO Ø0.625  
5. RIVET D3286-1 TO TUBE  
6. INSERT D3286-3 SPACER  
7. WELD IN PLACE AND GRIND FLUSH

**SECTION H-H**  
NOT TO SCALE D3-3

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09/06/17

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 4 OF 4
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4.9 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (D206-642)  
 32.19 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (ICA-D206-642)

ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -654	PART NUMBER	DESCRIPTION
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT

IS:

12B	16	16	16	16			D3672-7	WASHER
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WAS:

12B	16	16	16	16			D3672-5	WASHER
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79410

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	CP	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9467	SHEET 2 OF 2
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DE APPR.	<i>[Signature]</i>	WASHER CHANGE	NTS
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